










Date: Thursday, 19/03/2009 10:59:47 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE ASSEMBLY
Job Number	: 46564		
Estimate Number	: 13488		
P.O. Number	:	Part Number	: D3805041
This Issue	: 19/03/2009 S.O. No. :	Drawing Number	: D3805 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 46394	Material	:
Written By	:	Due Date	: 06/04/2009 Qty: 2 Um: Each
Checked & Approved By	19090319		
Comment	: Est Rev:A 08-07-21 new issue DD verified by:EC Est Rev:B 09-03-04 rev.a as per dwg DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D38051	Plate	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Fwd Plate batch: B46623 EL 9-4-2			
2.0	D38061	Bar	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bar batch: B46624 1-7 9-4-2			
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		 (P10) →	
Comment: LARGE FABRICATION RESOURCE 1 1- on D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH#: M11036 2-weld D3806-1 to wearplate by positioning holes together as per dwg D3805 304 S.S. Welding Rod BATCH #: M106115 EL 9-4-2			
4.0	QC9	VISUAL WELDING INSPECTION	
			
Comment: VISUAL WELDING INSPECTION PD 09-04-02 (2)			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D 3805-041 PAR #: N/A Fault Category: Eng / Dwg. NCR: (Yes) No DQA: D Date: 09/04/16
 Resolution: Documentation Review Disposition: EC - work QA: N/C Closed: D Date: 09/04/16

NCR: <u>46564</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/12	#30	to be able to form wedge plate wedge plate doesn't fit to slide tube. It has a large gap due to weld in R.C. Design Flaw		* ensure wedge plate is bolted to slide tube * cut a groove along center on Red end with a "Zip cut" length as required, width as required	EL 9-4-2	S 09/04/12	S 09/04/12	S 09/04/12
			09.04.02 PER 09/04/12	Form to fit slide tube. Re weld as per QSZ 004 304SS BATCH # <u>11106115</u>	EL 9-4-2	S 09/04/12	09.04.02 PER QSI 04/2	S 09/04/12
				Grind weld's Flush and Remove Any Forming marks	EL 9-4-2	S 09/04/12		S 09/04/12

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 46564

Part Number: D3805041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/08 (2)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 10/04/08

START TIME:

1:30

OVEN TEMPERATURE:

300

FINISH TIME:

2:00

FF 09-04-7

(2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09-04-07

(2)

8.0

D38071

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Gasket

batch:

B46566

FF 09-04-08

(2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip

adhesive as per dwg.

BATCH:

B46788

FF 09-04-08

(2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/08

(2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

FINISHING

29/4/08 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 10:59:47 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 46564

Part Number: D3805041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-08.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

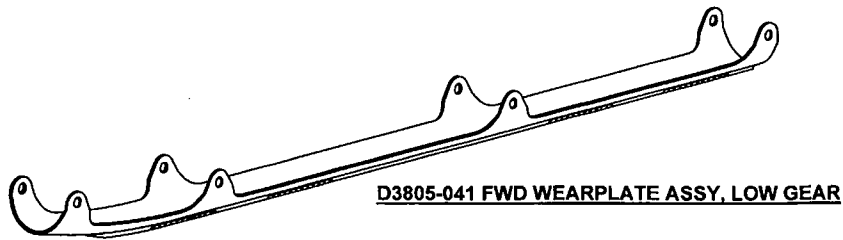
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

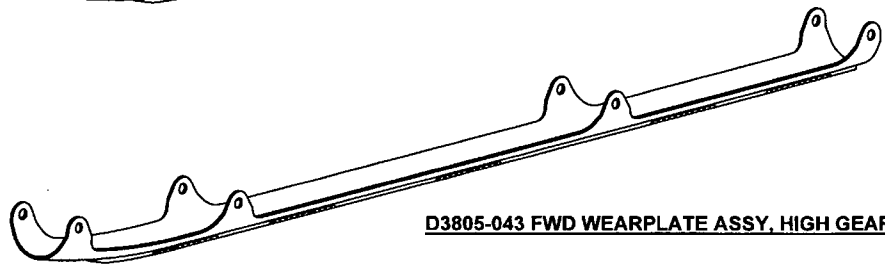
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

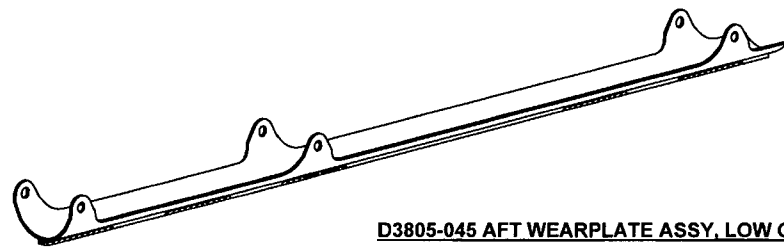
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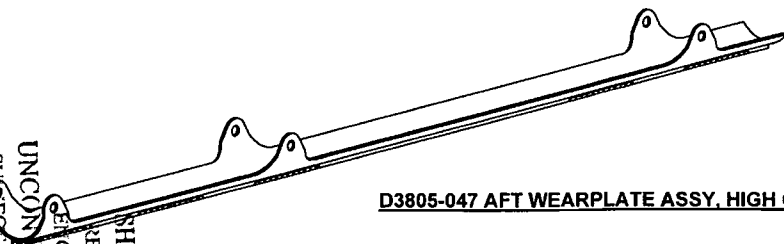
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

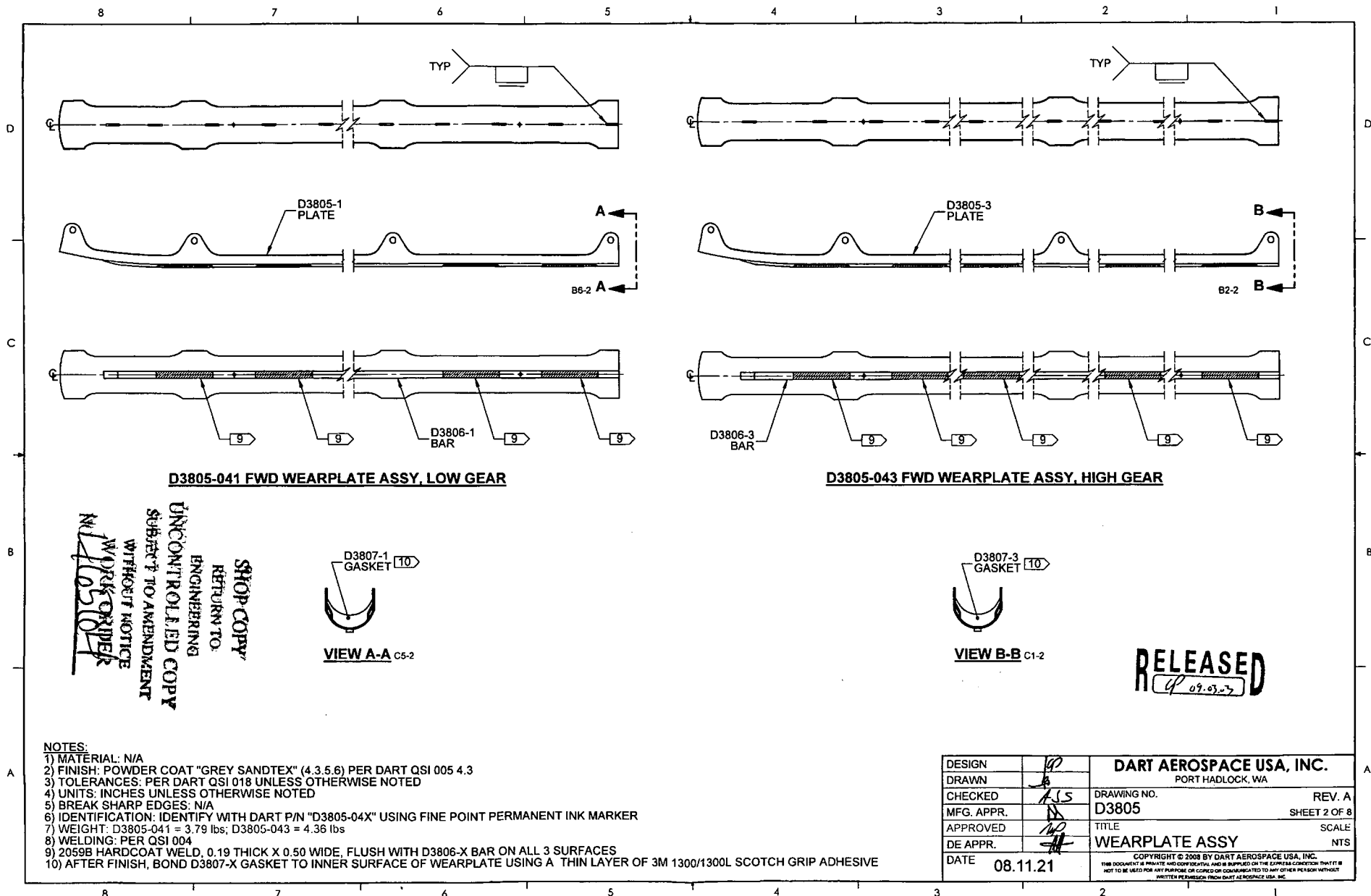
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

RELEASED
47 09.09.03
PLV ECN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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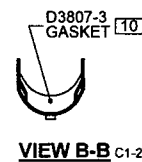
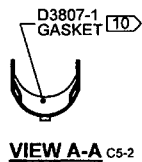
7 6 5 4 3 2 1



D3805-041 FWD WEARPLATE ASSY, LOW GEAR

D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

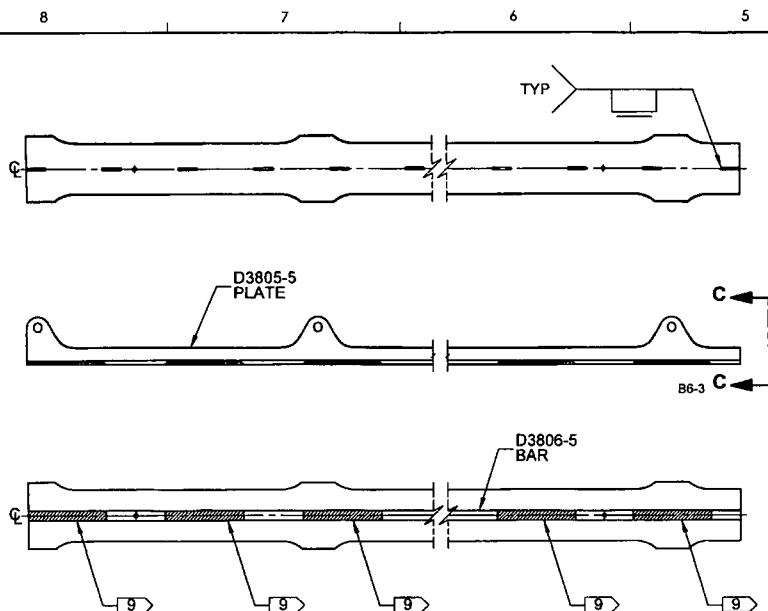
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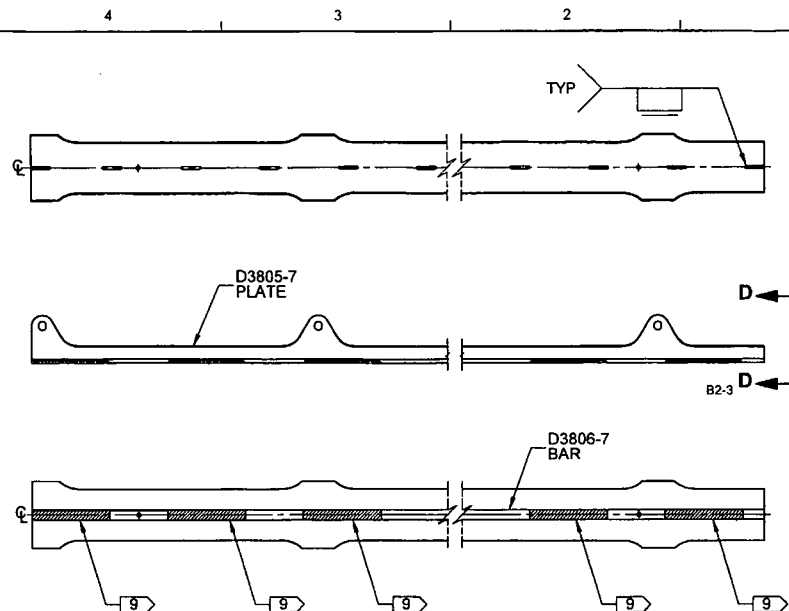
RELEASED
09.03.07

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

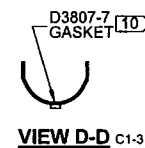
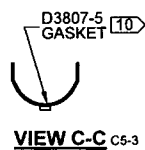
DESIGN	197	DART AEROSPACE USA, INC.	
DRAWN	18	PORT HADLOCK, WA	
CHECKED	215	DRAWING NO.	REV. A
MFG. APPR.	18	D3805	SHEET 2 OF 8
APPROVED	18	TITLE	SCALE
DE APPR.	18	WEARPLATE ASSY	NTS
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D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



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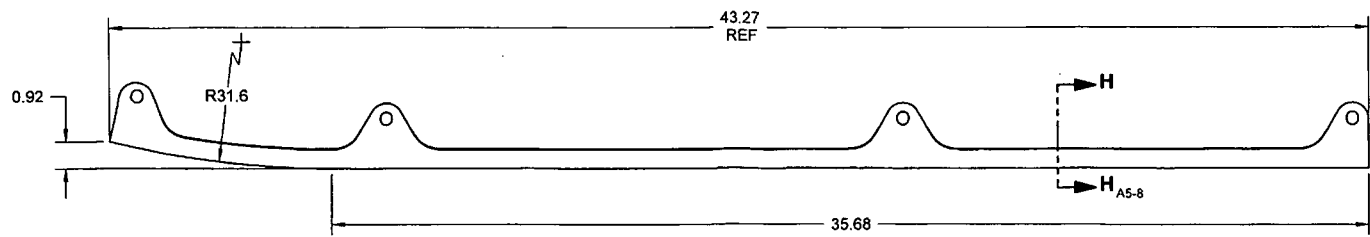
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

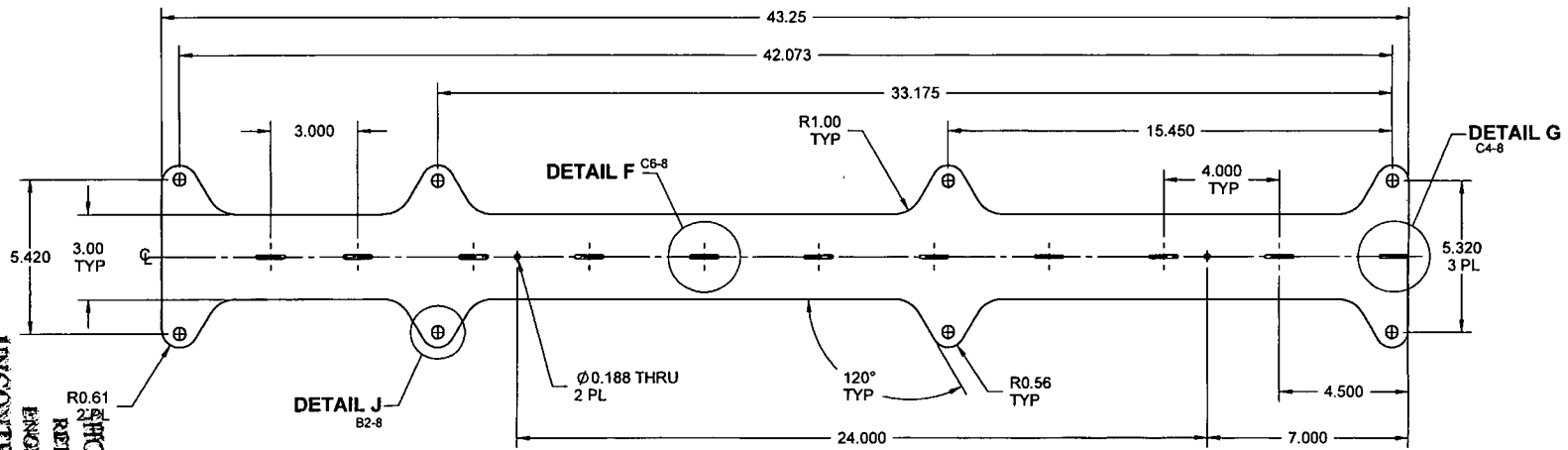
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MFG. APPR.	11	D3805	SHEET 3 OF 8
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8 7 6 5 4 3 2 1



D3805-1 PLATE
(MAKE FROM D3805-1F)



D3805-1F PLATE

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01.03.07

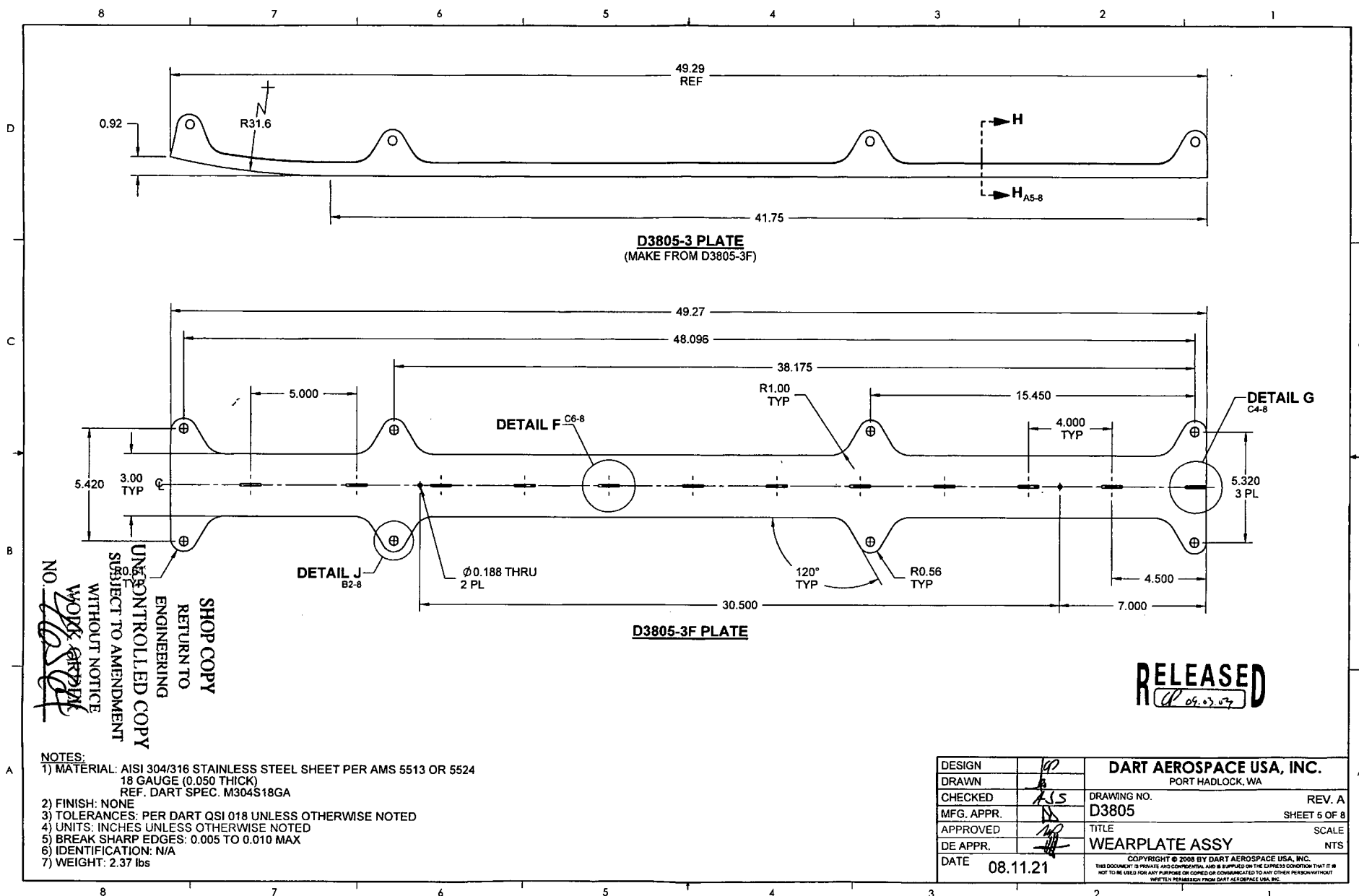
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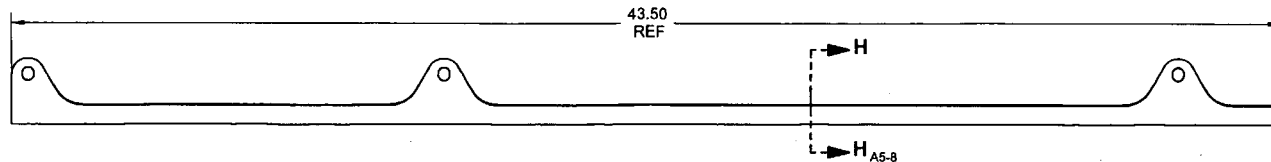
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

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MFG. APPR.	11	D3805	SHEET 4 OF 8
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DE APPR.	11	WEARPLATE ASSY	NTS
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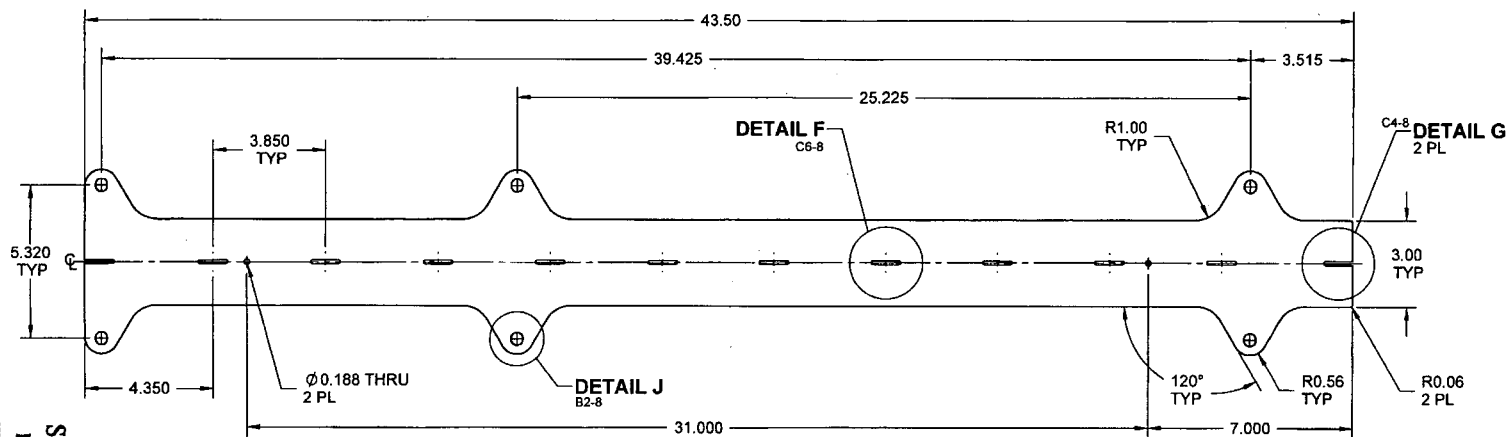
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8 7 6 5 4 3 2 1





D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

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CP 09-03-03

NOTES:

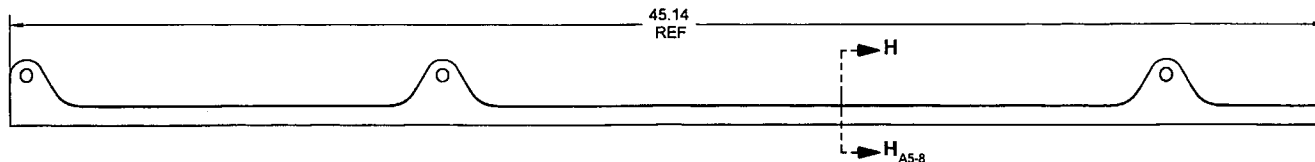
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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

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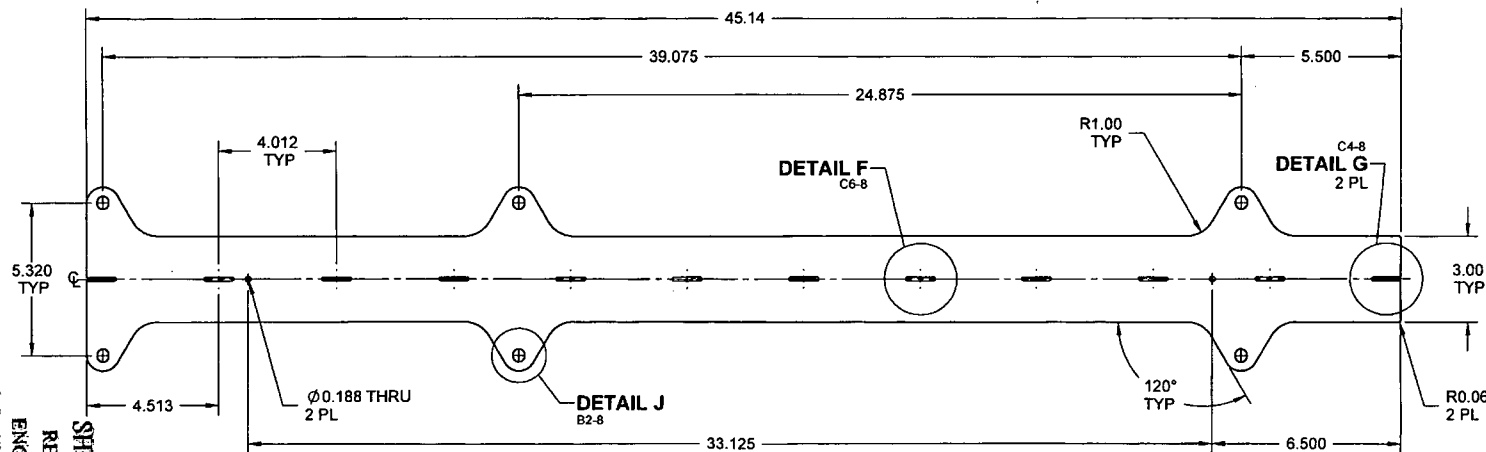
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DRAWN	JP	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO. D3805	REV. A
MFG. APPR.	JP	SHEET 6 OF 8	
APPROVED	JP	TITLE	
DE APPR.	JP	SCALE	
DATE	08.11.21	WEARPLATE ASSY	
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8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

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09.03.07

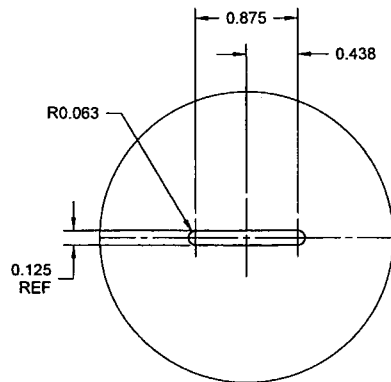
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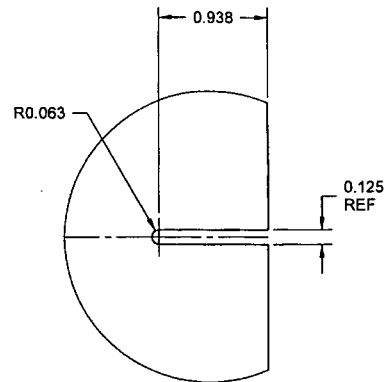
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	10	DART AEROSPACE USA, INC.	
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MFG. APPR.	10	SHEET 7 OF 8	
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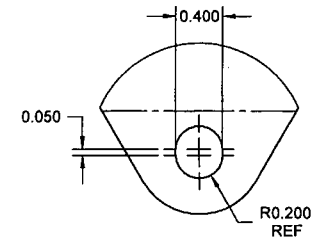
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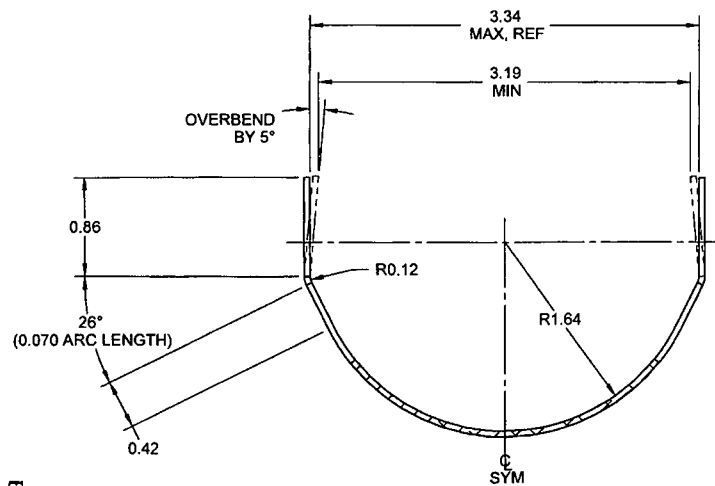
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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4709.03.03

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MFG. APPR.	197	D3805	SHEET 8 OF 8
APPROVED	197	TITLE	SCALE
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